



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5469-1
Job Sheet 188002



Part No: D5469-1

Job Qty: 10 pcs

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	2/20/19		0.00	19.81	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL / 14/02/22
							HAAS - 4		
120	QC 2	10 pcs	2/20/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		SBL 14/02/22



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S155902



Part: D5469-1

Job No: 188002

Serial No/Batch: S155902

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/22/19

130 QC 8	10 pcs	2/20/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	mk 19/03/05
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	2/20/19	0.00 1.41	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/03/05
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 -	

				B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150	Spray Paint - 2 - B4B	10 pcs	2/20/19	0.00	0.24	Spray Paint - 1 - B4B
						RD 19-3-6
				Spray Paint - 2 - B4B		
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
160	QC 14	10 pcs	2/20/19	0.00	0.00	QC 14 - 15
				QC 14 - 2		
				QC 14 - 34		
				QC 14 - 38		
				QC 14 - 41		
				QC 14 - 51		
				QC 14 - 58		
				QC 14 - 59		
				QC 14 - 9		MAR 11 2019
				QC 14 - 68		DAS 40 9-89
170	Packaging 3-1 - Stock - B4B	10 pcs	2/20/19	0.00	0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		54389 84 MAR 12 2019

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	10 pcs	2/20/19	0.00 / 0.00	QC 21 - SA - 21
				QC 21 - SA - 70	
					DAS MAR 12 2019 70
Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per 89 Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: <u>5152590</u> 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: <u>146086</u> 160 - (QC14- Inspect Spray Paint) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-005	Saddle Billet	10 pcs (1 ea)	100-HAAS 4 Axis	<u>5147786</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-005	10	32	0	
Part Specifications					
Specifications could not be found.					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5469-1
Job Sheet 188002



Part No: D5469-1

Job Qty: 10 ea

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD. IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	2/20/19	2/20/19	0.00	0.00	Start Up Machining-4		
100	CNC Vertical Machining	10 pcs	2/20/19	2/20/19	0.00	19.81	HAAS1-1		
120	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC2 Machining-4		
130	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC8 Machining-4		
140	HandFinish	10 pcs	2/20/19	2/20/19	0.00	1.41	HandFinish1		
150	SprayPaint	10 pcs	2/20/19	2/20/19	0.00	0.24	Spray Paint		
160	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC14		
170	Packaging	10 pcs	2/20/19	2/20/19	0.00	0.00	Packaging3-2		
180	QC21-SA	10 Ea	2/20/19	2/20/19	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FB548 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp
150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	10	12	0

Part Specifications

Specifications could not be found.

Plex 12/31/18 1:01 PM dart.white.jesse

Handwritten signature and number 3

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	D5469-1
Inspection Dwg: D5469-1 Rev: A DSK:		Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.438	0.443		0.438	0.438	0.438	0.438	0.438
B	1.745	1.755		1.750	1.750	1.750	1.750	1.750
C	3.495	3.505		3.500	3.500	3.500	3.500	3.500
D	1.745	1.755		1.750	1.750	1.750	1.750	1.750
E	7.990	8.010		8.003	8.007	8.001	8.000 ³	8.000
F	0.490	0.510		0.502	0.502	0.499	0.496	0.500
G	0.257	0.262		0.257	0.257	0.257	0.257	0.257
H	0.375	0.380		0.378	0.378	0.378	0.378	0.378
I	0.490	0.510		0.500	0.500	0.4975	0.502	0.501
J	1.174	1.184		1.179	1.179	1.179	1.179	1.179
K	0.558	0.578		0.567	0.568	0.568	0.567	0.566
L	1.174	1.184		1.179	1.179	1.179	1.179	1.179
M	1.365	1.375		1.370	1.370	1.370	1.370	1.370
N	2.495	2.505		2.500	2.500	2.500	2.500	2.500
O	4.119	4.129		4.124	4.124	4.124	4.124	4.124
P	0.115	0.135		0.130	0.130	0.130	0.130	0.130
Q	0.115	0.135		0.126	0.126	0.126	0.126	0.125
R	0.240	0.260		0.253	0.254	0.254	0.254	0.253
S	0.115	0.135		0.127	0.126 ³	0.129	0.128	0.127
T	0.178	0.198		0.188	0.188	0.188	0.188	0.188
U	3.210	3.250		3.236	3.236	3.236	3.236	3.236
V	0.230	0.250		0.243	0.242	0.241	0.242	0.2425
W	0.115	0.135		0.135	0.135	0.135	0.131	0.133
AI	2.000	2.020		2.003	2.003	2.003	2.003	2.003
Z	0.362	0.372		0.368	0.370	0.368	0.369	0.368
AA	0.470	0.530		0.500	0.500	0.500	0.500	0.500
AB	0.615	0.635		0.625	0.623 ³	0.625	0.623	0.623
AC	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AD	0.240	0.260		0.254	0.253	0.256	0.252	0.252 ³
AE	1.500	1.520		1.515	1.515	1.515	1.515	1.515
AF	0.115	0.135		0.130	0.130	0.130	0.130	0.130
AG	0.240	0.280		0.250	0.250	0.250	0.250	0.250
AH	0.240	0.260		0.250	0.250	0.250	0.250	0.250

DAS Accept/Reject

Measured by:	57 9-89	Date:	19/02/27
Audited by:	<i>ml</i>	Date:	19/03/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD			Work Order:	
Description:			Part Number: D5469-1	
Inspection Dwg: D5469-1 Rev: A DSK: Rev:			Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
A	0.438	0.443 ✓		0.438	0.438	438	438	438
B	1.745	1.755 ✓		1.750	1.750	1.750	1.750	1.750
C	3.495	3.505 ✓		3.500	3.500	3.500	3.500	3.500
D	1.745	1.755 ✓		1.750	1.750	1.750	1.750	1.750
E	7.990	8.010		8.000	8.000	8.000	8.000	8.000
F	0.490	0.510		497	496	494	502	500
G	0.257	0.262 ✓		0.257	0.257	257	257	257
H	0.375	0.380 ✓		0.378	0.378	378	378	375
I	0.490	0.510		499	500	500	500	500
J	1.174	1.184 ✓		1.179	1.179	1.179	1.179	1.179
K	0.558	0.578		467	468	468	469	468
L	1.174	1.184 ✓		1.179	1.179	1.179	1.179	1.179
M	1.365	1.375 ✓		1.370	1.370	1.370	1.370	1.370
N	2.495	2.505 ✓		2.500	2.500	2.500	2.500	2.500
O	4.119	4.129 ✓		4.124	4.124	4.124	4.124	4.124
P	0.115	0.135		0.130	0.130	126	133	130
Q	0.115	0.135		0.126	0.126	126	126	126
R	0.240	0.260		0.252	0.252	253	253	252
S	0.115	0.135		127	127	129	129	127
T	0.178	0.188 ✓		0.188	0.188	188	188	188
U	3.210	3.250 ✓		3.236	3.236	3.239	3.230	3.230
V	0.230	0.250		241	241	240	240	240
W	0.115	0.135		133	133	133	134	133
AI	2.000	2.020 ✓		2.003	2.003	2.003	2.003	2.003
Z	0.362	0.372		368	368	368	368	369
AA	0.470	0.530 ✓		0.500	0.500	500	500	500
AB	0.615	0.635		623	623	623	623	623
AC	0.053	0.073		061	061	061	063	062
AD	0.240	0.260		251	251	250	251	251
AE	1.500	1.520 ✓		1.515	1.515	1.515	1.515	1.515
AF	0.115	0.135		130	130	130	0.128	128
AG	0.240	0.280 ✓		0.250	0.250	250	250	250
AH	0.240	0.260 ✓		0.250	0.250	254	252	252

DAS Accept/Reject

Measured by: 57	Date: 19/02/27
Audited by: 9-89 <i>mf</i>	Date: 19/03/05
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	